0.00

Memo

QC

Quality Control

												DQA:	D	ate:	
NCR:	es /	/ No				WORK ORDER NON-C	100	NFORM	ANCE / UP	DATE			•		
									-			QA Closed:	D	ate:	
						DISPOSITION				AGAINST D	ÞΕ	PARTMENT	PROCESS		
Work Orde	er:	· · · · · · · · · · · · · · · · · · ·		-		P1	,		cui a a a a a a a a a a a a a a a a a a a	с			Water Je		En ain a avin a
0						Rework			Skid-tube	Crosstube		Dro		\vdash	Engineering Quality
Part i	vo					Scrap Use-as-is			Machining	Small Fab	_		d. Eng. Coor e/Packagin	-	Other
NCR I	No.					Work Order Update			noforming Large Fab	Finishing Composite		Rec/Stor	Supplie	_	Other
NCN	··· —					Work Order Opdate	ַ		Laige Fab	Composite			Jupplie	ا ا	
Root	Т	,			Descri	ption of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty	d	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificati	on	QC Inspector
Doc/Data															
Equip/Tooling														!	
Operator							•								
Material								, ,							
Setup													•		
Other					ļ										
Process		٠													
Supplier															
Training												! !			
Unapproved							<u> </u>					<u>[</u>			
						F.	AUL	T CATE	GCIRY						
Landi	ng Ge	ar				General		-		-		•			1
	ЫВ	ending				Bend		Grain				Ovalized			Pressure/Forced
	Щc	entre No	ot Concer	ntric to	o/s	BOM/Route	\perp	Hardwa	re	Ļ		Over/Under	tolerance	igspace	Temperature/Cure
	L C	racks				Broken/Damaged	<u></u>	Inspecti	on Incomplete	. [Part Incorre	ct	<u> </u>	Weld
	Щc	rushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/M	ssing	L	Wrong Stock Pulled
	C	uffs				Contamination		Mainte	nance			Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Order ID 94517 Page 2 December-19-12 11:35:06 AM D3255-5 Item ID: Accept *N900040100* Setup Start **Revision ID:** Gasket Item Name: **Start Date:** 12/19/12 Start Otv: 4.00 **Cust Item ID:** Required Date: 1/11/13 Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Operation Accept Insp. Set Up/ Work Center ID Run Hours Otv Description Code Otv Number Stamp 120 OC8- Inspect parts - second check *120* Memo **Ouality Control** Identify as per dwg & Stock Location: 0.00 130 *120* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo **Quality Control**

01301-21

									DQA:_	Date: _	
NCR: Yes	s / No				WORK ORDER NON-C	CONFORM	/ANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
Part No NCR No					Rework Scrap Use-as-is Work Order Update	Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet I. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	I ption of work order update	Initial	Ã	ction	Sign &		·
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling] .						1				
Operator							I				
√laterial	_						İ				
Setup											
Other		1	1			1	i		1		

Landing C	Gear	General		_	_	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Г	Offset	·	
	Torque Waves in Extrusion	Drawing	Г	Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

FAULT CATEGORY

Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-19-12 11:35:06 AM

Work Order ID:

94517

Parent Item:

D3255-5

Parent Item Name:

Gasket

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A04.05.12New issueKJ/RF

IPP Rev: B Now On Wateriet 06-08-14 II M

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	- 0	Date Issued	Status
D3255		Manufactured	No			110	sf	24.0000	1.5411	6.488842	6.5		
Gasket											<u> 1313-1</u>		
				Location		Loc Qty	Lo	c Code			C .		
				MAT052		24					(4)		
				838	1 7	24			\$394	(1	_		

											DQA:	Date:	
NCR: Y	es ,	/ No				WORK ORDER-NON-O	COI	VFOR	MANCE / UP	DATE		_	•
											QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work orde	-' -			· · · -	<u> </u>	Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part N	4o					Scrap			Machining	Small Fab	1	d. Eng. Coor.	Quality
						Use-as-is	4	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o. <u> </u>					Work Order Update	J		Large Fab	Composite	j	Supplier	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			•										
Operator													
Material	_												
Setup									Ì				
Other													
Process						· ·							
Supplier	Н		ļ										
Training	Н												
Unapproved	Ш.		<u> </u>	1	l		<u> </u>	TCATE	CORY				
							AUI	LT CATE	GURY				
Landir					Γ	General	Γ	Grain		<u> </u>	Ovalized	Г	Pressure/Forced
	\vdash	ending	ot Concer	atria ta	O/5	Bend BOM/Route	-	Hardwa	aro.	-	Over/Under	toloranco	Temperature/Cure
	\vdash	entre iv Tracks	or concer	itric to	^{0/3} -	Broken/Damaged	-	1	ion Incomplete	<u> </u>	Part Incorre		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabelec

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

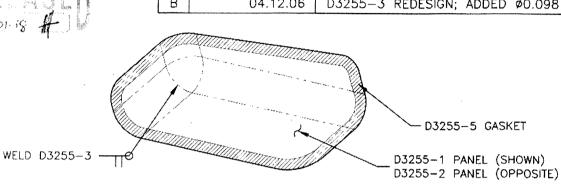
DART AEROSPACE LTD	Work Order:	94517
Description: Gasket	Part Number:	D3255-5
Inspection Dwg: D3255 Rev: B		Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Artic	ele	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comm	nents
1.00	+/-0.030`	1,001	7		V 1352		
18.46	+/-0.030	18.46	~		1007		
11.43	+/-0.030	11.43	U		7		
15.36	+/-0.030	15.36	U		7		
6.90	+/-0.030	6.90	K		7		
0.063	+/-0.010	1620,	L		V		
			O.A.				
easured by: R		Audited by:	25	/ 	Prototype App	proval:	N/A
Date: 13-		Date:	13-1-1	P	, , , , , , , , , , , , , , , , , , ,	Date:	N/A

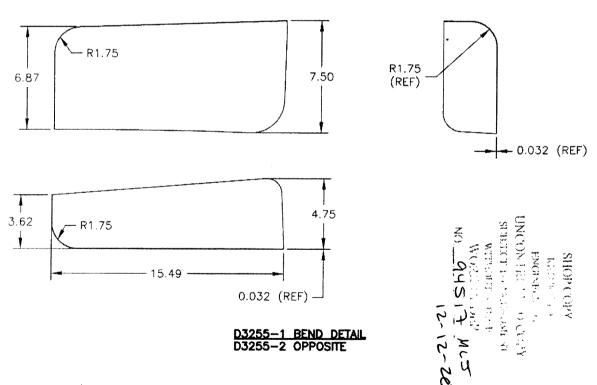
Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue	KJ/JLM	E



DESIG	N F	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED 10	APPROVED	DRAWING NO. REV. B
	W	H-	D3255 SHEET 1 OF 4
DATE			TITLE SCALE
 04.1	2.06		ACCESS PANEL ASSEMBLY 1:6
Α		04.01.27	NEW ISSUE
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)

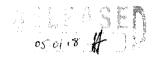


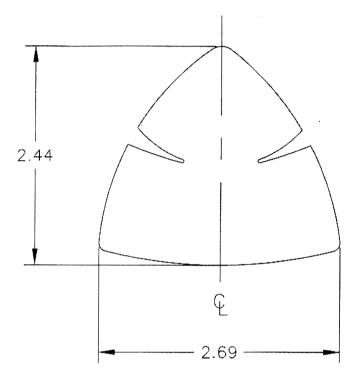
D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN	DRAWN BY	1	ROSPACE LTD Y, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
41	1	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

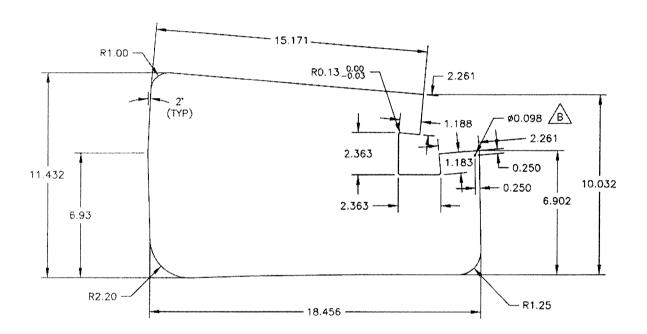
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED ##	drawing no. D3255	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





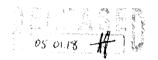
D3255-1/-2 FLAT PATTERN

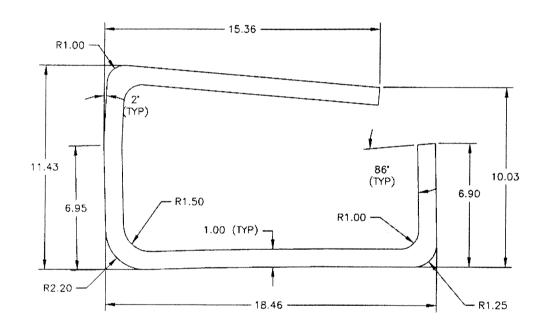
D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECKED	APPROYED	DRAWING NO.	REV. B
4	1	D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

- D3255-5 NOTES:

 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES